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CA 2149133 C 2003/06/17

(11)(21) **2 149 133**

(12) **BREVET CANADIEN
CANADIAN PATENT**

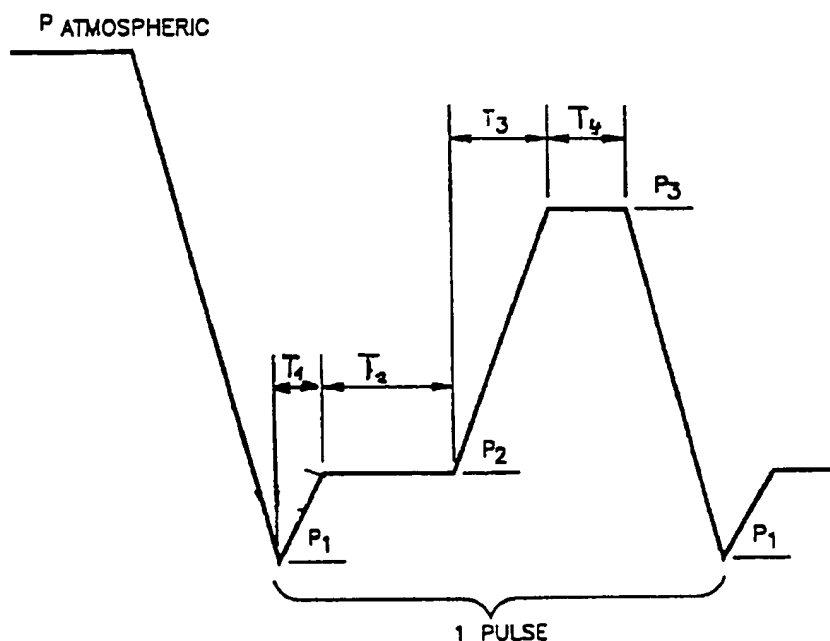
(13) C

(86) Date de dépôt PCT/PCT Filing Date: 1993/11/11
(87) Date publication PCT/PCT Publication Date: 1994/05/26
(45) Date de délivrance/Issue Date: 2003/06/17
(85) Entrée phase nationale/National Entry: 1995/05/10
(86) N° demande PCT/PCT Application No.: US 1993/011079
(87) N° publication PCT/PCT Publication No.: 1994/011035
(30) Priorité/Priority: 1992/11/12 (973,372) US

(51) Cl.Int.⁶/Int.Cl.⁶ A61L 2/20
(72) Inventeurs/Inventors:
CHILDERS, ROBERT WARREN, US;
GAGNE, DONALD RUSSELL, US
(73) Propriétaire/Owner:
AMERICAN STERILIZER COMPANY, US
(74) Agent: RIDOUT & MAYBEE LLP

(54) Titre : METHODE DE PENETRATION AMELIOREE DE CHIMIO STERILISANTS DURANT LA STERILISATION A FAIBLE PRESSION DE VAPEUR

(54) Title: A METHOD OF ENHANCED PENETRATION OF LOW VAPOR PRESSURE CHEMICAL VAPOR STERILANTS DURING STERILIZATION



(57) Abrégé/Abstract:

A method of improving the delivery of low vapor pressure chemical vapor sterilant into complex objects, such as lumens and piping dead legs using vapor compression.

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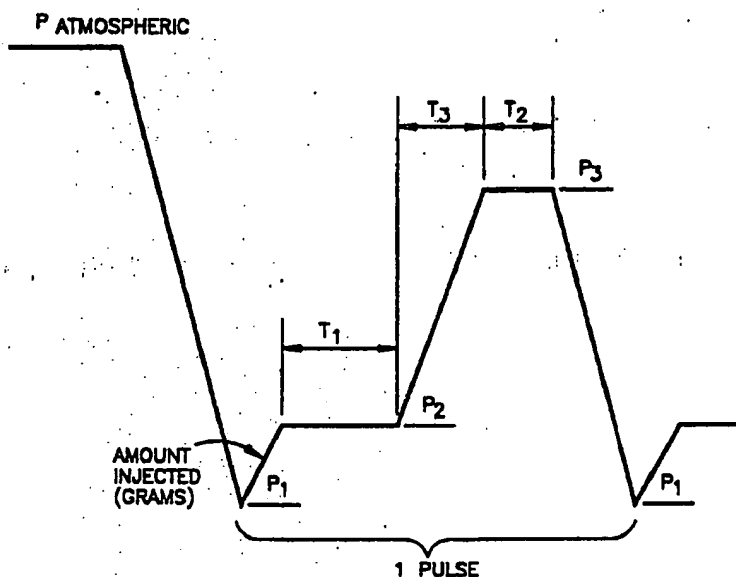
WORLD INTELLECTUAL PROPERTY ORGANIZATION
International Bureau



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁵ : A61L 2/20	A1	(11) International Publication Number: WO 94/11035 (43) International Publication Date: 26 May 1994 (26.05.94)
(21) International Application Number: PCT/US93/11079 (22) International Filing Date: 11 November 1993 (11.11.93) (30) Priority data: 973,372 12 November 1992 (12.11.92) US (71) Applicant: AMERICAN STERILIZER COMPANY [US/US]; 2424 West 23rd Street, P.O. Box 620, Erie, PA 16514 (US). (72) Inventors: CHILDERS, Robert, W. ; 102 Easton Court, Garner, NC 27528 (US). GAGNE, Donald, R. ; 5220 Troutman Lane, Raleigh, NC 27612 (US). (74) Agents: O'HEARN, Timothy, J. et al.; Jones, Day, Reavis & Pogue, North Point, 901 Lakeside Avenue, Cleveland, OH 44114 (US).		(81) Designated States: CA, JP, European patent (AT, BE, CH, DE, DK, ES, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE). 2149133 Published <i>With international search report. Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.</i>

(54) Title: **A METHOD OF ENHANCED PENETRATION OF LOW VAPOR PRESSURE CHEMICAL VAPOR STERILANTS DURING STERILIZATION**



(57) Abstract

A method of improving the delivery of low vapor pressure chemical vapor sterilant into complex objects, such as lumens and piping dead legs using vapor compression.

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A METHOD OF ENHANCED PENETRATION OF
LOW VAPOR PRESSURE CHEMICAL VAPOR
STERILANTS DURING STERILIZATION

10

Field of Invention

15

The present invention relates to
sterilization of various articles and, in
particular, to the use of vapor compression of
low vapor pressure chemical vapor sterilants to
20 sterilize articles of complex and irregular shape.

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BACKGROUND OF THE INVENTION

Complex objects which may contain a variety of narrow apertures, holes or tubes are difficult to sterilize. In particular, open ended lumens, internal cavities, deadlegs and flat surfaces in close proximity present difficulties. In situ sterilization of freeze dryers and sterilization of deadlegs and lumens created by piping external to the freeze drying chamber that is corroded, has a small external leak, or an extremely high depth to diameter ratio can also present an extreme challenge. Moreover, lumens and deadlegs which absorb sterilant material to any degree can also be difficult to sterilize.

Sterilization of complex objects is currently accomplished by using wet or dry heat, chemicals, ionizing radiation, electron beams, microwaves, arc discharges, lasers, plasmas and high vapor pressure chemical gases. Heat, penetrating radiation, or high vapor pressure chemical gases, have been preferred for sterilizing articles of irregular shape because of their ability to effectuate sterilization within narrow apertures, holes and tubes which are otherwise difficult to access. Each of these methods, however, has limitations and problems.

For the purposes of this invention the term sterilization means a 6 log (or greater) reduction in bioburden.

A number of these sterilization methods are discussed in "Principles and Methods of Sterilization in Health Sciences", second edition, written by John J. Perkins and published by Charles C. Thomas of Springfield, Illinois.

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A table for dry heat sterilization containing adequate exposure times for a variety of temperatures contained in Perkins on page 289 is reproduced as Table A below.

5

Table A
Dry Heat Sterilization Time-Temperature Ratios
Exposure Temperature Exposure Time

10	Degrees C	Degree F	
	180	356	30 minutes
	170	340	1 hour
	160	320	2 hours
15	150	300	2-1/2 hours
	140	285	3 hours
	121	250	6 hours

20 Dry heat sterilization does not require any pressure, but it is very difficult, and quite impractical, to heat complicated objects such as an entire freeze dryer and its associated piping to these high temperatures using electric or gas
25 heaters or with hot air.

Moist heat sterilization is much easier to implement since the introduction of saturated steam into a complicated object such as a freeze dryer will supply both the heat and the moisture.

30 A table for moist heat sterilization containing adequate exposure times for a variety of temperatures (Perkins, page 161) is reproduced as Table B, below.

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Table B

Moist Heat Sterilization Time-Temperature Ratios

	Exposure Temperature Degrees C	Temperature Degree F	Corresponding Pressure	Exposure Time
5	138	280	49.2 psia	0.8 Minutes
	132	270	41.9 psia	2 Minutes
	125	257	33.7 psia	8 Minutes
	121	250	29.8 psia	12 Minutes
10	118	245	27.3 psia	18 Minutes
	116	240	25.0 psia	30 Minutes

Both Tables A and B contain exposure
 15 times and do not account for the time required for
 all of the components within the object such as a
 freeze dryer and its associated piping to come up
 to temperature.

According to "Temperature Profiles and
 20 Sterilization within a Dead-ended Tube", written
 by Jack J. Young and Barbara L. Ferko and
 published in the July-August issue of the Journal
 of Parenteral Science & Technology, the time for a
 dead leg to come up to temperature can be
 25 considerable.

The data from Table III in Young et al
 for dead leg sterilization at 121°C is reproduced
 in Table C, below. Note that all of these times,
 which account for coming up to temperature, are
 30 much longer than the exposure times recommended by
 Perkins (Table B). Freeze drying piping dead legs
 are typically sloped at around 5° so they will
 drain, and they often are longer than those
 discussed in Young, et al. Thus, it would be
 35 expected to require sterilization times in excess
 of 358 minutes to completely sterilize a freeze
 dryer and its associated piping.

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Table C
Estimated Sterilization Times Within Dead-ended
Tubes For Varying Tube Orientations

5	Distance up Tube	Percent into Tube	Sterilization Time (minutes)		
			Vertical up	45° Up	5° Up
	1.8 cm	19.2	29.8	24.0	23.5
	3.1 cm	33.0	31.2	54.3	72.5
	4.3 cm	45.8	64.4	117.3	206.0
10	5.6 cm	59.8	68.0	121.4	358.3
	6.9 cm	73.6	101.3	N.T.	N.T.
	8.1 cm	86.4	167.3	N.T.	N.T.

- 15 The time required to heat up, sterilize, and cool down a massive object such as a freeze dryer will substantially reduce the time available for the Object (freeze dryer) to be used for its intended purpose (freeze drying). The addition of
- 20 "jackets" to heat and cool the chamber and condenser on a freeze dryer can decrease this time substantially, i.e. from 24 hours to 8 hours, but at the expense of thermally stressing the chamber, condenser and associated piping. This thermal
- 25 stress, when alternated with the extreme cold (-40°C) associated with freeze drying will propagate leaks and can actually cause the chamber and/or condenser to crack and have to be replaced periodically at great expense in time.
- 30 Gaseous chemical sterilization agents such as ethylene oxide can sterilize within 2-1/2 hours, but an extended aeration time, up to 24 hours, is required to remove the residuals. Disposal of the expended sterilant is also
- 35 difficult because it is considered both toxic and carcinogenic. Some states, California for example, require that any products that have been in contact with ethylene oxide be labeled as

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being processed with a known carcinogen. This would put a manufacturer at a disadvantage with a competitor who used a different sterilization process.

- 5 Use of pure concentrated ethylene oxide sterilant can be dangerous because it is explosive when mixed with oxygen (both during and at the end of the cycle when air is admitted into the chamber) so it is typically mixed with a diluent
10 such as Freon (which is being banned because it is an ozone depleter) before it is introduced into the sterilization chamber.

- Ionizing radiation must be of sufficient highly energy to penetrate articles effectively.
15 This necessitates the use of x-rays and/or gamma rays, both of which require large and expensive apparatus and are generally hazardous. Furthermore, ionizing radiation could not be expected to penetrate effectively around through
20 and into all of the metal components and down the piping within a complex object such as a freeze dryer.

- Use of low vapor pressure chemical vapor sterilants avoid some of the above-mentioned
25 concern and limitations, but because it is also difficult for them to penetrate into the holes, openings and apertures of complex shaped articles, several methods attempting to enhance their penetration characteristics have been considered.
30 These methods typically include: (1) deep evacuation of the sterilizing chamber prior to introduction of the sterilant; (2) alternating of evacuation pulses and sterilant introduction pulses; (3) increasing sterilant concentration
35 and/or pre-injection chamber pressure; (4) direct

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coupling and flowing or recirculating the sterilant through the lumen or object; and (5) continuously "pressure pulsing" during the sterilization phase.

5 U.S. Patent No. 4,348,357 provides a method for plasma pulsations. U.S. Patent No. 4,296,067 provides a method of sterilizing material, especially bandage and surgical instruments, in a steam autoclave operating as
10 near to vacuum as possible. And finally, U.S. Patent No. 4,372,916 discloses a method which utilizes alternating evacuation and sterilant introduction pulses.

Each of the above mentioned methods are
15 designed to enhance sterilant penetration, but all continue to fall short of being ideal.

Achieving an increase in sterilant penetration performance by use of a deep vacuum as suggested by U.S. Patent No. 4,296,067 has been
20 verified. Tests ran by AMSCO, and contained in Table D, below verified that this method would work for hydrogen peroxide vapor. However, as seen in the table this concept when used with low vapor pressure gases requires the vacuum level to
25 be of the order of 1 Torr or less to achieve best results. This requirement results in excessive pump down times, and expensive pumping equipment. In addition the results obtained using this technique are achievable with fewer deep vacuum
30 pulses when using the invention proposed herein.

Table D
Average Hydrogen Peroxide Vapor
Sterilant Penetration into 1 cm ID x 120 cm
Deep Passivated Stainless Steel Deadlegs

	Pre-Injection Vacuum Level	2-1/2 Ft ³ Chamber		154 Ft ³ Chamber	
		Depth of Penetration (cm)	(percent)	Depth of Penetration (cm)	(percent)
5					
10	10 Torr	N.T.	N.T.	60	50
	5 Torr	80	67	60	50
	2 Torr	80	67	73	61
	1 Torr	90	75	87	73
15	0.1 Torr	115	96	N.A.	N.A.

Sterilant penetration results were not available for the large chamber because the vacuum system was unable to evacuate to 0.1 Torr. A very expensive pump would have been capable of doing so but the cycle time would have increased substantially in the process.

A dead leg shape containing coupons inoculated with 1×10^6 *Bacillus Stearothermophilus* spores ~~was illustrated in Figure 1~~ was placed inside an 81 liter chamber that had a leak rate (pressure rise) of 150 microns per minute. The chamber was then evacuated to 0.1 Torr prior to the introduction of hydrogen peroxide vapor which increased the pressure to about 6 Torr. After a six minute sterilize hold the chamber was re-evacuated and the sterilize pulse repeated. After 9 sterilize pulses all the coupons were sterile.

This same dead leg was located external to, but attached to the chamber using the KF40 adapter. The chamber leak rate (pressure rise) now increased to 230 microns per minute due to a

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leak rate into the dead leg of about 0.0085 standard liters per minute. After a 9 pulse sterilize cycle, which was identical to that ran when the dead leg was inside the chamber, none of
5 the coupons was found to be sterile. The enhanced penetration due to the use of a deep pre-injection vacuum was insufficient to overcome the small leak in the external dead leg.

Thus, when sterilizing large, complex
10 objects such as a freeze dryer the deep pre-injection vacuum was found to be very expensive to implement, to have long cycle times and to be unable to sterilize external piping dead legs with small leaks.

15 The method of alternating evacuation pulses and sterilant introduction pulses discussed in U.S. Patent No. 4,372,916 was evaluated on the 154 Ft³ chamber using hydrogen peroxide vapor. The results of this evaluation for an evacuation
20 of 1 Torr are included in Table E. The test was conducted using 1 in I.D. x 120cm deep passivated stainless steel dead legs containing inoculated with 1.0×10^{10} *Bacillus stearothermophilus* spores as the biological challenge.

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Table E
Number Positive/Number
Tested for Sterility

5	Depth of Penetration from open end (cm)	4	8	16	32
		Sterilize Pulses	Sterilize Pulses	Sterilize Pulses	Sterilize Pulses
	0	0/6	0/2	0/2	0/2
10	10	0/6	0/2	0/2	0/2
	20	0/6	0/2	0/2	0/2
	30	0/6	0/2	0/2	0/2
	40	0/6	0/2	0/2	0/2
	50	0/6	0/2	0/2	0/2
15	60	0/6	0/2	0/2	0/2
	65	0/6	0/2	0/2	0/2
	70	0/6	0/2	0/2	0/2
	75	3/6	0/2	0/2	0/2
	80	3/6	0/2	0/2	0/2
20	90	4/6	1/2	0/2	0/2
	100	6/6	2/2	1/2	0/2
	110	6/6	2/2	1/2	0/2
	120	6/6	2/2	2/2	0/2

25

This method would work but it was found to take 16 to 32 sterilize pulses to be equal in performance to the deep pre-injection vacuum method discussed previously.

30

Simply increasing the concentration of the hydrogen peroxide vapor in the 154 cubic foot chamber was also tested at various pre-injection vacuum levels. Table F contains the data for this method.

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Table F

**Average Hydrogen Peroxide Vapor
Sterilant Penetration into
1 cm I.D. x 120 cm Deep Passivated
Stainless Steel Deadlegs**

	Pre-Injection Vacuum Level	Amount of Sterilant Injected per pulse	Depth of Penetration (cm)	Depth of Penetration (percent)
10	10 Torr	28 grams	58	48
		35 grams	60	50
		42 grams	75	63
15		56 grams	90	75
	5 Torr	35 grams	60	50
	2 Torr	28 grams	60	50
		35 grams	73	61
		42 grams	80	67
20		56 grams	76	63
	1 Torr	56 grams	87	73

The data for a 4 pulse sterilization cycle shows that increasing the concentration will enhance penetration somewhat but will not result in the desired level of penetration performance. Residual levels were higher after aeration when increased amounts of sterilant were introduced. This is presumably because the saturation, or dew point, conditions were exceeded and condensation occurred. Further increase in the amount injected resulted in excessive condensation and prolonged aeration as well as decreased depth of penetration.

The direct coupling process described in U.S. Patent No. 4,372,916 is not always practical because all dead ended configurations must be converted to flow through configurations in order to implement such a method. This restructuring would be particularly impractical for objects contained in, for example, a freeze dryer chamber and condenser.

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There is a need for a method which can sterilize complex objects by using low vapor pressure chemical vapor sterilants. There is a further need for enhancing the penetration of such
5 sterilants into the openings and apertures of such complex objects being sterilized. There is a further need for a method which can be used in both small scale applications and large scale applications without being prohibitive with
10 respect to cost of sterilization cycle time.

SUMMARY OF INVENTION

It is therefore a main object of the present invention to provide a method of enhancing
15 the penetration of low vapor pressure chemical vapor sterilants into the apertures and openings of complex objects.

Additional objects and advantages of the invention will be set forth in part in the
20 description which follows, and in part will be obvious from the description, or may be learned by practice of the invention. The objects and advantages of the invention may be realized and obtained by means of instrumentalities and
25 combinations particularly pointed out in the appended claims.

To achieve these objects and in accordance with the purpose of the invention, the present invention provides a method of enhancing
30 the vapor sterilant penetration of complex objects such as lumens by using air dry air (less than 5% R.H.) or inert gas to drive the vapor that has diffused into closed or open ended lumens by further down the lumen than it could naturally
35 diffuse. The addition of the air, or dry air or

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inert gas creates a higher pressure differential, and thus flows, than would naturally occur by pulsing in a low pressure sterilant. This more rapid flow helps to overcome absorption and decomposition of the sterilant. For purpose described here in low vapor sterilant means any gas sterilant where the active component has a partial pressure less than 30mm of Hg. A vacuum is pulled following the vapor compression, removing the residual sterilant vapors (and humidity) and thus preparing the system for the next sterilization pulse.

The method may also be combined with other known methods such as deep evacuation of the chamber prior to the introduction of the sterilant, alternating of evacuation pulses and sterilant introduction pulses, increasing sterilant concentration, and direct coupling and flowing the sterilant through the article.

20

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

The present invention overcomes the disadvantages of current sterilization methods by using air, dry air, sterilant laden air or an inert gas such as helium or nitrogen to compress the vapor sterilant that has diffused into closed and opened end lumens. The air acts as a piston which pushes and compresses the vapor further of the lumen and is sufficiently fast so that diffusion, decomposition or an external leak does not offset the enhancing effect of the compression. The concentrated sterilant gases or vapors then sterilize the most remote portion of the lumen in a timely and efficient manner. Opened end lumens will behave similarly to closed

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end lumens with vapor entering from each end. The sterilant will be pushed toward the center of the lumen when subjected to vapor compression. Typically the vapor compression itself has a
5 duration of less than one minute but longer air bleed times are also helpful. After an exposure time, a vacuum pulldown follows the vapor compression in order to remove the residual sterilant vapors and eliminate humidity in
10 preparation for the next sterilization pulse. This is an advantage for sterilants whose allowable concentrations are maximized when the pre-introduction humidity is at a minimum.

In a first embodiment of the invention, a
15 closed end lumen is placed in a closed sterilization chamber at atmospheric pressure (760 Torr). The chamber is first evacuated to a pressure of less than or equal to 40 Torr, preferably between about 0.1 Torr to 10 Torr.
20 Sterilant vapors are then introduced, raising the pressure in the chamber to a pressure which is greater than or equal to twice the initial, evacuated pressure, typically between .2 Torr and 80 Torr, preferably between about 6 Torr and 60
25 Torr. The preferred sterilant vapors are generated from electronic grade hydrogen peroxide, food grade hydrogen peroxide, peracetic acid, acetic acid, or mixtures thereof. The vapor is allowed to distribute itself throughout the
30 chamber and into the dead end lumen for a time period which is normally less than or equal to twice the half life of the sterilant, based upon the environment within the chamber. For purpose

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here the half life is that time required for the sterilant concentration to be reduced by $1/2$ either due to decomposition or absorption.

The vapor compression pulse begins when
5 air, dry air, sterilant laden air, or some other inert gas such as helium or nitrogen, is admitted into the chamber. Consequently, the pressure within the chamber is raised to a pressure typically greater than 6 times the previous
10 pressure preferably between about 36 Torr and 360 Torr, within a pre-determined time T. Time T is typically less than 1 minute in duration. The sterilant is then allowed to remain inside the tube for a time period which is normally greater
15 than or equal to its half life while inside the tube. The chamber is then evacuated again to a pressure of less than or equal to 40 Torr and the procedure is repeated until sterilization is achieved.

20 In a second embodiment of the invention, an opened end lumen is placed in a closed sterilization chamber at atmospheric pressure (760 Torr). Sterilant vapors are introduced from each end of the lumen. Similarly, vapor compression
25 pulsations enter the opened end lumen from each end and the sterilant vapor is pushed further into the lumen than it would otherwise diffuse. The sterilization process is then carried on in essentially the same manner as that for a closed
30 end lumen.

In determining the time T in which the pressure is raised to achieve vapor compression and the number of times the procedure must be

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repeated in order to achieve an optimum kill potential, the following calculations are considered.

For the sake of simplicity, it will be assumed that the half life of the sterilant inside the tube is equal to the time it takes for the concentration at the dead end of the tube to rise an amount equal to 1/4 of the average concentration gradient between the inlet of the tube and the dead end of the tube. At time $T=0$, the concentration at the inlet is equal to C and the concentration at the dead end is 0. At time $T = HL$ (half life of sterilant inside tube), the concentration at the inlet has fallen to $1/2 C$ and the concentration at the dead end has risen to $1/4 \times ((C + C/2)/2 - 0) = 3/16 C$. At time $T = 2HL$, the concentration at the inlet has fallen to $1/4 C$ and the concentration at the dead end has become $1/4 \times ((1/2 C + 1/4 C)/2 - 3/16 C) + 1/2 \times 3/16 C = 3/32 C$ (since only half of what was present at the dead end of the tube at time $T = HL$ remains at time $T = 2HL$).

This pattern continues until, after an infinite sterilize hold period, the total kill potential (concentration \times time) at the inlet of the tube can be calculated as the sum of the average kill potentials for each half life interval. This is found to be equal to an infinite series:

$$HL * (C + C/2)/2 + HL * (C/2 + C/4)/2 + \\ HL * (C/4 + C/8)/2 + HL * (C/8 + C/16)/2 + HL * (C/16 + C/32)/2 + \dots$$

which simplifies to

$$(3 * HL * C/2) * (1/2 + 1/4 + 1/8 + 1/16 \dots)$$

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and finally to

$3*HL*C/2$ = kill potential at inlet to tube.

The kill potential at the dead end of the tube is found in a similar manner. However, the series is slightly more complex since the first time half life interval is different from the remaining half life intervals. After an infinite sterilize hold period, the total kill potential results in an infinite series:

$$HL*(0 + 3C/16)/2 + HL*(3C/16 + 3C/32)/2 + \\ HL*(3C/32 + 3C/64)/2 + HL*(3C/64 + 3C/128)/2 + HL * (3C/128 + 3C/256)/2 \\ +$$

which simplifies to

$$HL * 3C/32 + HL * 9C/32 * (1/2 + 1/4 + 1/8 + 1/16 + . . .)$$

and finally to

$3*HL*C/8$ = kill potential at the dead end of tube.

Thus, it would be expected to require four times as many sterilize pulses to sterilize the dead end of the tube as it would to sterilize the inlet to the tube.

By using these formulas it can be determined that if a 6:1 vapor compression pulse were to occur from the inlet of the tube towards the end of the tube at time $T=2HL$, the entire vapor contents of the tube would be compressed into the bottom one sixth of the tube near the dead end. Hence, the vapor concentration at the dead end would then be $((C/4 + 3C/32)/2) * 6 = 66C/64$.

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Furthermore, if the air used to compress the vapor was also sterilant laden, with concentration C no diffusion from the dead end of the tube would occur. The sterilant concentration at the dead end would then be reduced only by degradation according to the half life relationship.

In contrast, after a total sterilize time of $T=4HL$, the kill potential at the inlet of the tube without vapor compression will be

$$3HL \cdot C/4 + 3HL \cdot C/8 + 3HL \cdot C/16 + 3HL \cdot C/32 = 47HL \cdot C/32.$$

In a similar manner, the kill potential at the dead end of the tube with vapor compression will be

$$3HL \cdot C/32 + 9HL \cdot C/32 + 3HL \cdot C/4 + 3HL \cdot C/8 = 3HL \cdot C/2.$$

These two kill potentials are nearly identical meaning that the sterilization time at the dead end of the tube is nearly equal to the sterilization time at the inlet of the tube.

Brief Description of the Drawings

The present invention can best be understood by reference to the drawings, in which:

Figure 1 is a schematic diagram illustrating the sterilization cycle of the present invention

Detailed Description of the Drawings

Figure 1

The invention will be described in reference to Figure 1, which illustrates a portion of a vapor compression sterilization cycle.

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Typically, the sterilization chamber is initially at atmospheric pressure (760 Torr).

As depicted in Figure 1, the sterilization chamber is first evacuated to a pre-selected pressure P_1 , typically less than or equal to 40 Torr. Sterilant vapors are then introduced raising the pressure in the chamber to a second pre-determined pressure, P_2 typically at least twice P_1 in a pre-determined Time T_1 . P_2 is limited by the nature of the low pressure sterilant. The vapor is allowed to distribute itself throughout the chamber (including the dead end lumens) for a pre-determined time T_2 , which is normally less than or equal to twice the half life of the sterilant based upon the environment within the chamber. The vapor compression begins by admitting the air, dry air sterilant laden air or inert gas ("Pressure Gas") into the chamber. The Pressure Gas is admitted into the chamber raising the pressure to a third pre-determined pressure, P_3 , within a third pre-determined Time T_3 . Time T_3 is typically less than 1 minute in duration. Pressure P_3 is typically greater than six times pressure P_2 . The Pressure Gas and sterilant are then allowed to remain inside the tube for a fourth pre-determined time, T_4 , which is normally greater than or equal to the half of the sterilant life while inside the tube. The chamber is then evacuated again to pressure P_1 and the procedure is repeated.

The pressure, time ranges and number of pulsations will vary between articles, depending on the particular object and its application. The following are but illustrative examples of the present invention as applied on various samples.

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EXAMPLES**Example 1**

Biologicals consisting of 10^6 Bacillus
steorothemophilus spores is placed along stainless
5 steel strips of 120 cm, every 10 centimeters. The
steel strips are slide down into a 1 cm ID x 120
cm deep passivated stainless steel dead end tube.
The tube is then placed inside a 2-1/2 cubic foot
chamber at atmospheric pressure. The chamber is
10 first evacuated to various pressure ranging from
0.1 Torr to 5 Torr. Hydrogen peroxide vapors are
then introduced, raising the pressure in the
chamber by about 6 Torr. The hydrogen peroxide
vapor is generated from a solution of 31% hydrogen
15 peroxide by weight. The vapor is then allowed to
distribute itself throughout the chamber and into
the lumen for a time period of 1/2 minute.

Air is then admitted into the chamber.
The pressure is consequently raised to above 100
20 Torr within 20 seconds. The hydrogen peroxide
vapors is then allowed to remain inside the
chamber tube for a time period of 5 minutes. The
chamber is then re-evacuated and the sterilization
pulse repeated 4 times.

25

Example 2

The experiment in Example 1 can also be
conducted wherein hydrogen peroxide vapor is
introduced into a dessicated air stream which is
30 used to perform the vapor compression. This is
advantageous since the sterilant employed can be
used at a higher concentration when the initial
humidity is minimized.

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Example 3

A bacillus steorothemophilus spore carrier is placed in the center of a more complex, 3 meter long I.V. Set. The sample is then placed inside a sterilization chamber at 0.10 Torr. A vapor compression time of one minute is applied, resulting in a 6.0 log breakdown of the spore carrier. A 15 pulse cycle using the invention is sufficient to obtain complete sterilization. The hydrogen peroxide vapor is generated from a solution of 50% hydrogen peroxide by weight.

Example 4

Provided below are results of using the current sterilization method on a 1cm I.D. x 120 cm deep passivated stainless steel deadleg. The deadlegs were placed in a 154 cubic foot chamber and maintained at 77°F during a 4 pulse sterilization cycle. The data shows that vapor compression for 1 Torr and 2 Torr pre-injection vacuum levels penetrates deeper than an identical cycle not employing vapor compression. The vapor compression pulse went from 10 Torr to 165 Torr in 22 seconds.

Pre-Injection Vacuum Level	Amount of Sterilant Injected per pulse	Depth of Penetration with Vapor Compression		Depth of Penetration Without Vapor Compression	
		(cm)	(%)	(cm)	(%)
2 Torr	56 grams	93	78	76	63
1 Torr	56 grams	118	98	87	73

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Example 5

Provided below are results of using the current sterilization method on two 1cm I.D. x 120 cm deep passivated stainless steel deadleg. The deadlegs were placed in a 154 cubic foot chamber and maintained at 77°F during four pulse sterilization cycle. The amount of sterilant injected per pulse and the pre-injection evacuation pressure remained constant at 56 grams and 1 Torr, respectively.

	Depth of Penetration from open end (cm)	Number Positive/Number Tested for Sterility
15	0	0/8
	10	0/8
20	20	0/8
	30	0/8
	40	0/8
	50	0/8
	60	0/8
25	70	0/8
	80	0/8
	90	0/8
	100	0/8
	110	0/8
30	120	2/8

While this invention has been described in connection with preferred embodiments, it is not intended to limit the scope of the invention to particular embodiments set forth, but, to the contrary, it is intended to cover such alternatives, modifications, and equivalents as may be included within the spirit and scope of the invention as defined by the appended claims.

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Example 6

The experiment in Example 1 can also be conducted wherein the sterilant vapor is generated from a solution that is a mixture of peracetic acid, acetic acid, hydrogen peroxide, and water. 5 VigorOx Santitizer, produced by FMC, is such a solution which is 5.2% peracetic acid, 21.7% hydrogen peroxide, 10.4% acetic acid and 62.7% water.



(New) Claims

1. A method of enhancing penetration of low vapor pressure
5 sterilant vapors during sterilization of an article in
an enclosed chamber comprising the consecutive step of:
(a) evacuating said chamber to a pre-determined pressure
below atmospheric pressure;
(b) introducing sterilant vapors into said chamber and,
10 consequently, raising the pressure in said chamber
to a second pre-determined pressure below atmospheric
pressure in a pre-determined time;
(c) allowing said sterilant vapors to be distributed
throughout said chamber for a pre-determined time
15 period;
(d) introducing a gas into said chamber within a third
pre-determined time period, and raising the pressure
within said chamber to a pre-determined pressure
up to atmospheric pressure; and
20 (e) allowing said gas and said sterilant vapors to remain
in said chamber for a pre-determined time period.
(f) repeating steps (a) - (e) as needed to obtain a
pre-determined level of sterilization.
25
2. The method of claim 1, wherein in the evacuating step,
the first pre-determined pressure is less than or equal
to 40 Torr.
- 30 3. The method of claim 1, wherein in the evacuating step
the first pre-determined pressure is from between about
0.1 Torr and 10 Torr.
4. The method of claim 1, wherein in the step of introducing
35 sterilant vapors into the chamber pressure is
raised to the second pre-determined pressure of greater

AMENDED SHEET



than or equal to twice the first pre-determined pressure.

- 5 5. The method of claim 1, wherein during the step of introducing sterilant vapors into the chamber the second pre-determined pressure is from between about 6 Torr and 60 Torr.
- 10 6. The method of claim 1, wherein the second pre-determined time period is less than or equal to twice the half-life of said sterilant vapor within the enclosed chamber.
- 15 7. The method of claim 1, wherein the third pre-determined time period is from about 3 to 120 seconds.
- 20 8. The method of claim 1, wherein the third pre-determined pressure is greater than six times the second pre-determined pressure.
- 25 9. The method of claim 1, wherein the third pre-determined pressure is between about 36 Torr and 360 Torr.
- 30 10. The method of claim 1, wherein the fourth pre-determined time period is greater than the half-life of said sterilant while inside said chamber.
- 35 11. The method of claim 1, wherein steps (a) through (e) are repeated between 2 and 32 times.
12. The method of claim 1, wherein said gas in step (d) is selected from the group consisting essentially of air, dry air, helium and nitrogen, and mixtures thereof.
13. The method of claim 1, wherein said sterilant vapor is generated from a solution selected from the group consisting essentially of hydrogen peroxide, hydrogen



peroxide and water, peracetic acid, acetic acid and mixtures thereof.

- 5 14. The method of claim 1, wherein the pressure differential between the third and second pressures is greater than the pressure differential between the second and first pressures.
- 10 15. The method of claim 1, wherein the vapor compression is sufficient to drive the sterilant vapor further into the article than the sterilant vapor would naturally diffuse.

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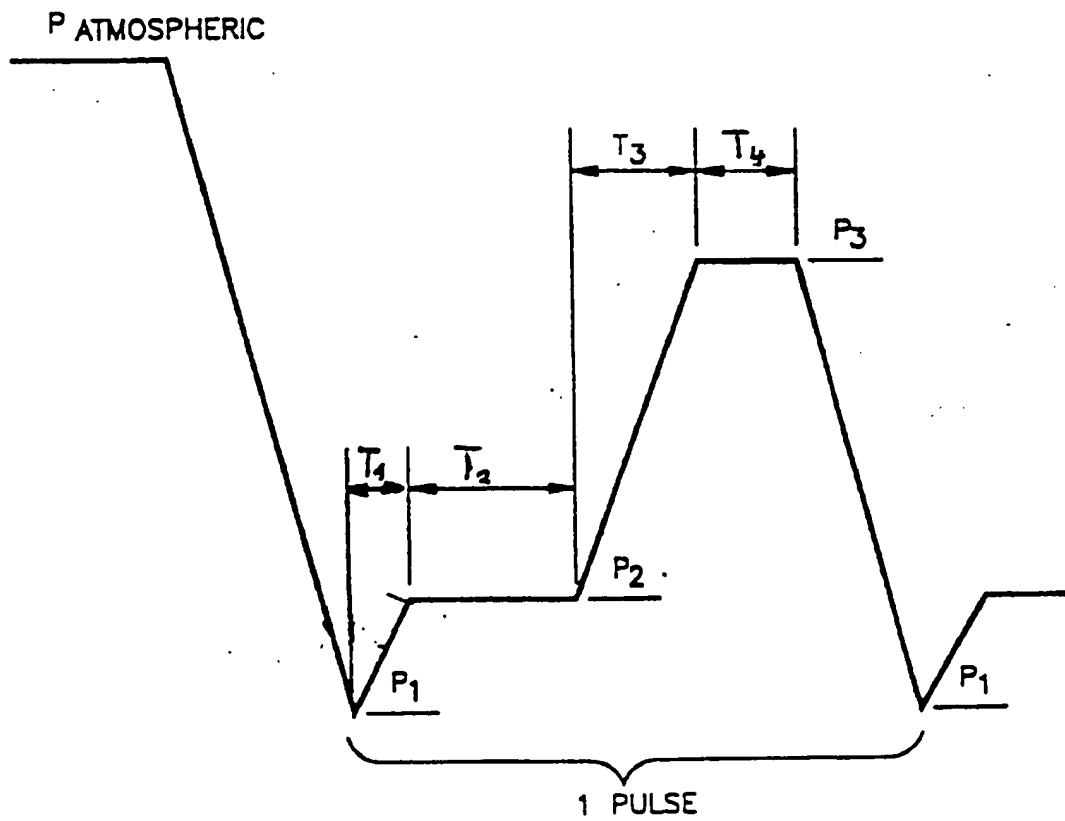


Fig.1

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